



Dart Aerospace Ltd.  
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Hawkesbury, ON  
K6A 1K7  
Canada

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ASAP

U/R

D4944-1

Job Sheet 197063



Part No: D4944-1

Job Qty: 60 pcs

Part Name: Gasket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/27/19

Job Tracking No:

Due Date: 10/26/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: URF 18-746, URF 19-802 DWG D4944 REV.D IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 9/10/17 AUTH SFB

RELEASED 19-10-19 DATE SFB

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   | Sign-off    |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-------------|
|       |                             |        |            |          | Setup Hrs | Run Hrs |                       |             |
| 100   | Small Fab - 1               | 60 pcs | 10/26/19   | 10/26/19 | 0.00      | 1.00    | Small Fab - 1         | OCT 18 2019 |
|       |                             |        |            |          |           |         | Small Fab - 2         |             |
|       |                             |        |            |          |           |         | Small Fab - 3         |             |
|       |                             |        |            |          |           |         | Small Fab - 4         |             |
|       |                             |        |            |          |           |         | Small Fab - 5         |             |
|       |                             |        |            |          |           |         | Small Fab - 6         |             |
|       |                             |        |            |          |           |         | Small Fab - 7         |             |
| 110   | QC 5                        | 60 pcs | 10/26/19   | 10/26/19 | 0.00      | 0.00    | QC 5 - 10             | OCT 8 2019  |
|       |                             |        |            |          |           |         | QC 5 - 12             |             |
|       |                             |        |            |          |           |         | QC 5 - 17             |             |
|       |                             |        |            |          |           |         | QC 5 - 18             |             |
|       |                             |        |            |          |           |         | QC 5 - 19             |             |
|       |                             |        |            |          |           |         | QC 5 - 22             |             |
|       |                             |        |            |          |           |         | QC 5 - 24             |             |
|       |                             |        |            |          |           |         | QC 5 - 3              |             |
|       |                             |        |            |          |           |         | QC 5 - 43             |             |
|       |                             |        |            |          |           |         | QC 5 - 49             |             |
|       |                             |        |            |          |           |         | QC 5 - 51             |             |
|       |                             |        |            |          |           |         | QC 5 - 58             |             |
|       |                             |        |            |          |           |         | QC 5 - 68             |             |
|       |                             |        |            |          |           |         | QC 5 - 9              |             |
|       |                             |        |            |          |           |         | QC 5 - 50             |             |
|       |                             |        |            |          |           |         | QC 5 - 30             |             |
|       |                             |        |            |          |           |         | QC 5 - 40             |             |
| 130   | Packaging 3-1 - Stock - B4B | 60 pcs | 10/26/19   | 10/26/19 | 0.00      | 0.00    | Packaging 3 - 1 - B4B | MLO         |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |             |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |             |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |             |
|       |                             |        |            |          |           |         | Packaging 3 - 5 - B4B |             |
|       |                             |        |            |          |           |         | Packaging 3 - 6 - B4B |             |
|       |                             |        |            |          |           |         | Packaging 3 - 7 - B4B |             |

Plex 10/17/19 11:16 AM dart.lacelle.linda



See  
Marcel  
D&A  
for  
concession

|                                    |                                              |                     |                   |                                                                          |        |          |           |                 |                   |             |
|------------------------------------|----------------------------------------------|---------------------|-------------------|--------------------------------------------------------------------------|--------|----------|-----------|-----------------|-------------------|-------------|
|                                    |                                              |                     |                   | Packaging 3 - 8 - B4B                                                    |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 9 - B4B                                                    |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 10 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 11 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 12 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 13 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 14 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 15 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 16 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 17 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 18 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 19 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 20 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 21 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 22 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 23 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 24 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 25 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 26 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 27 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 28 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 29 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 30 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 31 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 32 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 33 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 34 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 35 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Packaging 3 - 36 - B4B                                                   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | 140 QC 21 - SA                                                           | 60 pcs | 10/26/19 | 0.00 0.00 | QC 21 - SA - 21 | D&S<br>21<br>9-09 | OCT 18 2019 |
|                                    |                                              |                     |                   |                                                                          |        |          |           | QC 21 - SA - 70 |                   |             |
|                                    |                                              |                     |                   |                                                                          |        |          |           | QC 21 - SA - 53 |                   |             |
|                                    |                                              |                     |                   | Part Op <b>100</b> - 1-Cut as per Dwg                                    |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | Descriptions: <b>110</b> - QC5- Inspect part completeness to step on W/O |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | <b>130</b> - Identify as per dwg & Stock Location: _____ LOCATION : GA   |        |          |           |                 |                   |             |
|                                    |                                              |                     |                   | <b>140</b> - QC21- Final Inspection - Work Order Release                 |        |          |           |                 |                   |             |
| <b>Job BOM</b>                     |                                              |                     |                   |                                                                          |        |          |           |                 |                   |             |
| Part / Item                        | Component Name                               | Quantity            | Operation         | Container                                                                |        |          |           |                 |                   |             |
| M-SIL20-S.125                      | Red Hi-Temperature Closed Cell Silicone Foam | 7.4400 sf (.124 ea) | 100-Small Fab - 1 | 8153112                                                                  |        |          |           |                 |                   |             |
| <b>Job Allocations</b>             |                                              |                     |                   |                                                                          |        |          |           |                 |                   |             |
| Operation                          | Component Part                               | Required            | Inventory         | Allocated                                                                |        |          |           |                 |                   |             |
| 100-Small Fab - 1                  | M-SIL20-S.125                                | 7                   | 3                 | 0                                                                        |        |          |           |                 |                   |             |
| <b>Part Specifications</b>         |                                              |                     |                   |                                                                          |        |          |           |                 |                   |             |
| Specifications could not be found. |                                              |                     |                   |                                                                          |        |          |           |                 |                   |             |



**Container No: S223826**



**Part: D4944-1**

**Job No: 197063**

**Serial No/Batch: S223826**

**Revision: D**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Dart Aerospace Ltd.**

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Hawkesbury, ON K64 1K7

CANADA

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www.dartaerospace.com

Date: 10/16/19

## SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: RED HI-TEMPERATURE CLOSED CELL SILICONE FOAM  
TEXTURED BOTH SIDES

TENSILE STRENGTH: 100 psi

COMPRESSION DEFLECTION: 6-14 psi

TEMPERATURE RANGE: -103 TO +450°F (-75 TO 232°C)

DENSITY: 0.020 lbs/ in<sup>3</sup> (34 lbs/ ft<sup>3</sup>)

SPECIFICATION: AMS3195, MIL-R-46089, ASTM D1056, MIL-R-6130 & MIL-STD 670 TE12

POSSIBLE SUPPLIER: DIVERSIFIED SILICONE PRODUCTS P/N DSP1135M

PART NUMBER: M-SILDD-S.TTT

WHERE "DD" = DUROMETER OF SILICONE  
".TTT" = THICKNESS IN INCHES

EG. 0.125" THICK 60 DUROMETER CLOSED CELL SILICONE FOAM = M-SIL60-S.125

RELEASED

2019 FEB 07  
ECN 18-796

APPROVED

|            |                                   |                                                                                                                                                                                                                                                                              |              |
|------------|-----------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| B          | UPDATED P/N & SPEC; REF CAR18-255 | RF                                                                                                                                                                                                                                                                           | 18.10.19     |
| A          | NEW ISSUE                         | MB                                                                                                                                                                                                                                                                           | 06.02.02     |
| REV.       | DESCRIPTION                       | BY                                                                                                                                                                                                                                                                           | DATE         |
| DESIGN     | MB                                | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                            |              |
| DRAWN      | RF                                | DRAWING NO.                                                                                                                                                                                                                                                                  | REV. B       |
| CHECKED    | WK                                | M-SILDD-S                                                                                                                                                                                                                                                                    | SHEET 1 OF 1 |
| MFG. APPR. | DD                                | TITLE                                                                                                                                                                                                                                                                        | SCALE        |
| APPROVED   | VS                                | SILICONE SHEET                                                                                                                                                                                                                                                               | NTS          |
| DE APPR.   | DS                                | COPYRIGHT © 2018 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |
| DATE       | 18.10.19                          |                                                                                                                                                                                                                                                                              |              |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☒

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |                                                       |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|-------------------------------------------------------|------------------------|--|
| Job: <u>19 7063</u><br>Part No. <u>D4944-1</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input checked="" type="checkbox"/> |  | <b>DEPARTMENT/PROCESS</b><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div> |  |  |                                                       |                        |  |
| Date : <u>19.10.13</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | Sequence #: <u>100</u>                                                                                                                   |  | QTY Affected : <u>60</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  | MRB (QSI042)<br><b>DAS 51</b><br>9-89 <u>19/10/17</u> |                        |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                                          |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |                                                       | Completed By           |  |
| Make D4944-1 to Rev.D with<br>No Holes                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                          |  | *Acceptable with No holes<br>on Parts<br><br>* this will need a concession<br>Sign by Marcel DQA to<br>Send to Leonardo                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |                                                       |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |                                                       | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |                                                       | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><div style="display: flex; justify-content: space-between;"> <div>             Operator <input type="checkbox"/><br/>             Manufacturing Process <input type="checkbox"/><br/>             Equip/Tooling <input type="checkbox"/><br/>             Handling/Presservation <input type="checkbox"/><br/>             Material <input type="checkbox"/><br/>             Product Improvement <input checked="" type="checkbox"/><br/>             Process Improvement <input type="checkbox"/><br/>             Human Factors <input type="checkbox"/> </div> <div>             Pressure/Forced <input type="checkbox"/><br/>             Bending <input type="checkbox"/><br/>             Crushing <input type="checkbox"/><br/>             Cracks <input type="checkbox"/><br/>             Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br/>             Marks/Chatter <input type="checkbox"/><br/>             Mislabeled <input type="checkbox"/> </div> <div>             Contamination <input type="checkbox"/><br/>             Misaligned/off center <input type="checkbox"/><br/>             BOM/Route <input type="checkbox"/><br/>             Broken/Damage/Defect <input type="checkbox"/><br/>             Incomplete/Unclear Instructions <input type="checkbox"/><br/>             Drill Holes <input type="checkbox"/><br/>             Fit/Function <input checked="" type="checkbox"/> </div> <div>             Power Loss/Surge <input type="checkbox"/><br/>             Folio/Program <input type="checkbox"/><br/>             Grain Direction <input type="checkbox"/><br/>             Weld <input type="checkbox"/><br/>             Wrong Stock Pulled <input type="checkbox"/><br/>             Out of Sequence <input type="checkbox"/><br/>             Off-set/Set-up <input type="checkbox"/> </div> <div>             Positioned Wrong <input type="checkbox"/><br/>             Outside Tolerance <input type="checkbox"/><br/>             Drawing <input type="checkbox"/><br/>             Finish <input type="checkbox"/><br/>             Part Lost/Missing <input type="checkbox"/><br/>             Misread <input type="checkbox"/> </div> </div> |  |                                                                                                                                          |  | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                                                       |                        |  |